

Work Order ID 52252

Monday, September 21, 2009 2:23:12 PM

must ship 24/09



PRELIMINARY ISSUE

Page 1

Item ID: D3991-1

Accept



Setup Start



Revision ID: A-PRELIM

Stop



Item Name: Packer

Start Date: 9/22/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *PR*

Date: *09-21*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3991	A-PRELIM								

100

0.00



Waterjet

FLOW CNC Waterjet

606' 032

Memo

0.00

1-Cut as per Dwg. D3991

Dwg Rev: *PRF*

Prog Rev: *Lim*

2-Deburr if necessary

13 99-22

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

13 99-22

13

Monday, September 21, 2009 2:23:12 PM



Stop

[illegible]

Customer:

Required Date: 9/30/2009 **Req'd Qty:** 1.00

Reference:



Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Abstract

Insp.
Stamp

**ENGINEERING
APPROVAL**

0.00

Quality Control

0.00

HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00

QC

Memo

0.06

Work Order ID 52252

Monday, September 21, 2009 2:23:12 PM



Page 3

Item ID:	D3991-1	Accept		Setup	Start	
Revision ID:	A-PRELIM				Stop	
Item Name:	Packer					
Start Date:	9/22/2009	Start Qty:	1.00			
Required Date:	9/30/2009	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

SEE ATTACHED ECN

sent to Harvey - Engle
per ECN 09-673P

change to RD309A Sept

u 09-09-28

ACTIVE RECALL
09-09-21 AUTH
DATE _____

Picklist Print

Page 1

Monday, September 21, 2009 2:23:19 PM

Work Order ID: 52252



Parent Item: D3991-1RevA-PRELIM



Parent Item Name: Packer

Start Date: 9/22/2009

Required Date: 9/30/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	64.3858	0.0256	0768		
6061-T6 Sheet 0.032"												

189-9-22

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

64.3858

110063

0.9958

16954

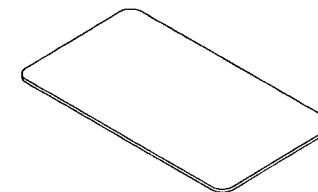
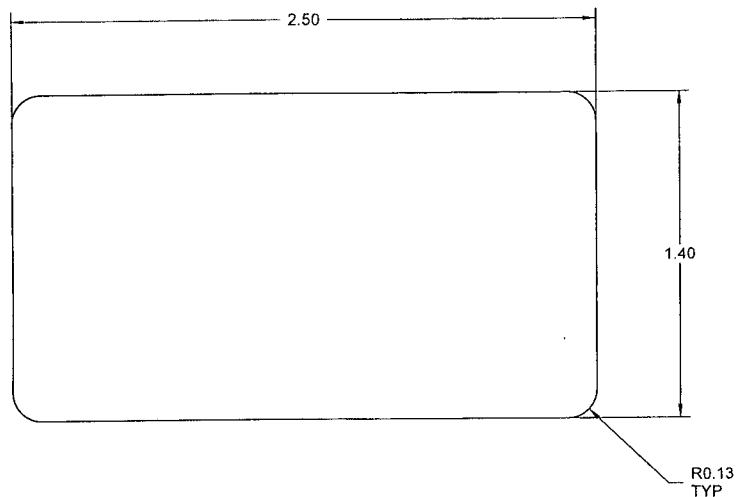
8.99

18375

54.4

110063

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 WITHOUT NOTICE
 WORK ORDER
 NO. 52252



0.032
REF

D3991-1 PACKER

PRELIMINARY ISSUE

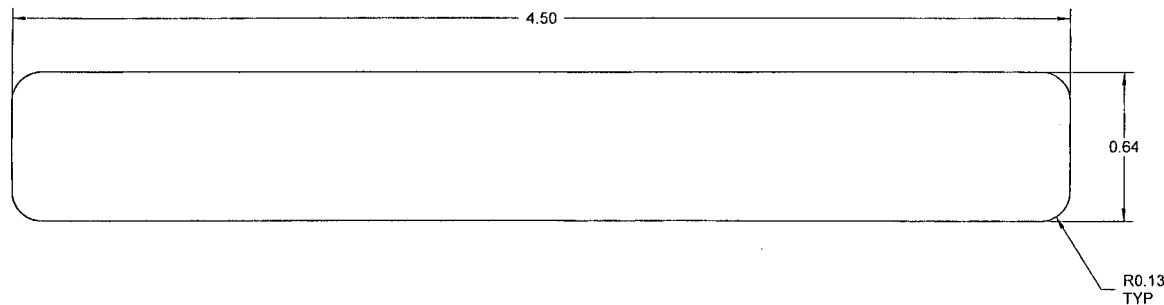
Handwritten signature/initials

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.032 THICK
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
 REF DART SPEC M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3991-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

A		NEW ISSUE		AS		09.09.14			
REV.		DESCRIPTION				BY		DATE	
DESIGN		AS		DART AEROSPACE LTD					
DRAWN		AS		HAWKESBURY, ONTARIO, CANADA					
CHECKED		DRAWING NO.				REV. A			
MFG. APPR.		D3991				SHEET 1 OF 2			
APPROVED		TITLE				SCALE			
DE APPR.		PACKER				NTS			
DATE		09.09.14				COPYRIGHT © 2009 BY DART AEROSPACE LTD			
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 WORK ORDER
 NO. 52252



D3991-3 PACKER

PRELIMINARY ISSUE
 09/09/14
 JMD

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.032 THICK
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- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3991-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3991	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PACKER	NTS
DATE	09.09.14	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Receiving Report

Date: 8/1/26

Batch No: M110063

Supplier: MAGNA

Dart P/O: 7606

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ N/A ☒
 Work Order 4242 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: 0811/28
 Date: 8/1/28
 Received/Costing: 809587
 Initial: CA

Location:

H:\FORMS\Purchasing\approved\...
 0001 10 .080" X 48" X 144"
 L017763 3 PC/166 LB
 3 PC 6061-T6 .032 X 48" X 144"
 L017765 3 PC/66 LB

3 PC	286.66	859.98
3 PC	120.00	360.00

RECEIVED DEC 04 2008

11/28/08 18:14:21

Merchandise:	2,135.98
Surcharges:	
No Tax Costs:	
GST	106.80
Total Due:	2,242.78

Title to the goods sent out on this invoice remains with Magna Stainless Div of CSM ULC until such time as this invoice has been paid in full. Unless otherwise noted terms are 30 days. Interest accrues on all overdue accounts at the rate of 1.5% per month compounded monthly.

Q.S.T. # 1213236471

8/2008 WED 11:36
Magna Stainless CHD

Alcoa Inc.

Ship From: REVERDALE, GA.

Wm. G. Lusk

Kenton P. Young

Kerton P. Young
Quality Assurance Manager

922270	0		Ship From:	RTV
Ship Date	B.L. No.	Invoice No.	Alego No. Item	
2008-05-24	2850767	08000	5099391-1	
P.O. No./Govt Contract No.	Customer	Mfg. Order		
PS0307JG001 Ln4: 1	YARDE-SOUTHINGTON DS-99391-1			

5/22/22

Q-012 IN TK 1+.0025 -.0025) X 48.0 IN W (+.125 -
 .125) X 144.0 IN LN (-.15625 -.15625) (W) A/T 6061-
 76 PLAT SHEET KILL FINISH. AMS-Q-A-250/11
 EKC MKK AMS4027.REV M 18 2007 ANH115.2 REV 2006 EKC_MKK AMS6-SB-
 209 REV 07 EKC MKK ASTHB207 REV 07
 ((MARKED)) KRAFT PAPER INTERLEAVED
 MAX GROSS SKID WGT: 4500 LB QUAN TOL +/-
 30 * CQR 0215323 REV 02 CUST REQ 08-05-
 12 *** N/E 08-05-24 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serial
1	845704	613761	4152	192	PC	
2	845719	613761	1903	88	PC	
			6055	280		

2
03/11/27

Notes for UQR: 0215323.2
PRODUCED BY THE U.S. GOVERNMENT

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ- A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11F. PROD UCT
PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.

CGR: 0215123.2 -Specification Units

Topx	Dir	UTS	YTS	SLAD
76	Long Transv.	KSI	KSI	PCT
		Max		
		Min	42.0	35.0
				10

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 6061	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15	
100: 613761	Min	0.40		0.15		0.8	0.04					
- Mechanical, Physical, Metallurgical, and Surface												
REMAIN												

Lot: 613761		Mechanical, Physical, Metallurgy, Quantumter Results			
Expr.	Dir	No->	UTS	TS	ELAD
T6	Long Transv.	Test	ksi	ksi	PCT
		2	48.9	39.1	14.6
			49.3	39.7	14.5

9527

1. 44444444

S81118DG009-5 MAGNA STAINLESS FO: F001744 Part #:

3.00PC . 66.00LB

005/006

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

We hereby certify that the material covered by this certificate has been inspected with and has been found to meet the applicable requirements described herein, including any specifications forming a part of this description and that samples representative of the material at run the composition tests and had the mechanical properties shown on the face of this sheet.

Mary J. Lusk

Mary J. Lusk
Director of Manufacturing Davenport Works

Karlton P. Young

Karlton P. Young
Quality Assurance Manager

922270 0
Ship Date B.L. No. Invoice No. Alcoa No. Item Page 2
2008-05-24 2950767 00000 5095391-1
P.O. No./Govt Contract No. Customer Mfg Order
789307JG001 Lot#: 1 YARDE-SOUTHERN 05-29391-1

Lot: 613761 - Mechanical, Physical, Metallurgy, Quantometer Results (cont.) -----
Cast Number Chemical SI SE CU MN MO CR ZN TI
H2759114 Actuals 0.65 0.4 0.28 0.06 1.0 0.19 0.04 0.02

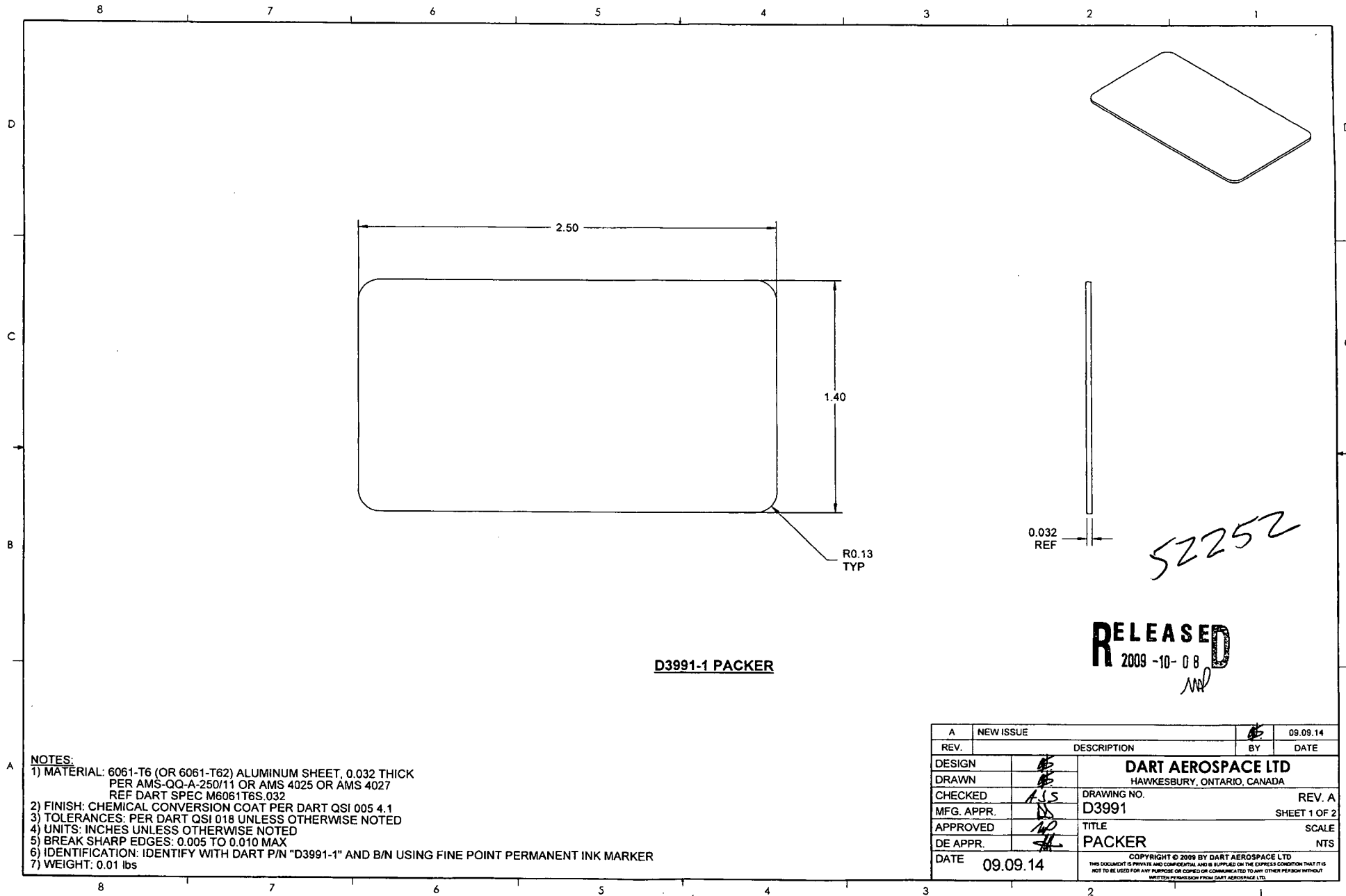
This material was melted in the United States or a Qualifying Country (REF DFARS 225.672.1(a)); it was manufactured in the United States

REF: C-000100 13:00 SHARP REINLD MICROTE NO

P. 001/001

SS 118DGD005-5 MAGNA STAINLESS FO: P001004 Part #:

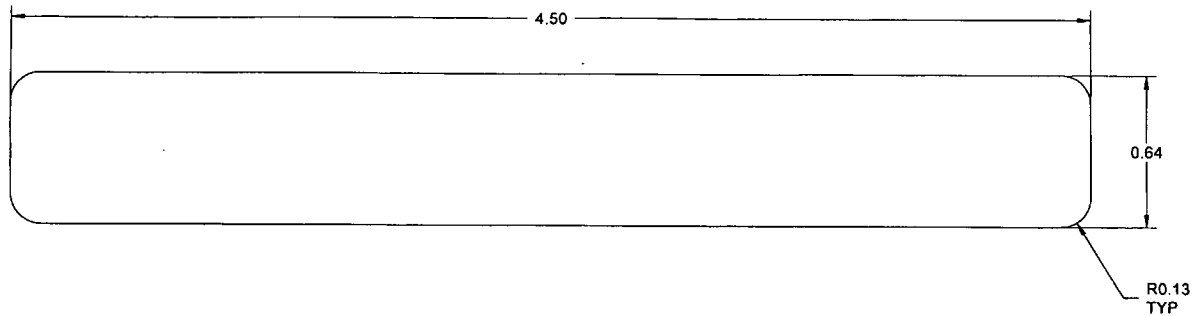
2007.99 2007.99



NOTES:

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- 7) WEIGHT: 0.01 lbs

A		NEW ISSUE		09.09.14	
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3991 TITLE PACKER			
DRAWN					
CHECKED	AJS				
MFG. APPR.					
APPROVED					
DE APPR.		REV. A SHEET 1 OF 2 SCALE NTS			
DATE		09.09.14			
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D3991-3 PACKER

52252

RELEASED
2009-10-08

NOTES:

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- 7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	1.5	DRAWING NO.	REV. A
MFG. APPR.		D3991	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PACKER	NTS
DATE	09.09.14	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date: 09.09.21	Job No.: P2010009	ADR Yes/No: No	ADR Date:	ECN #: 09- 673P
Product No.: D350-600 / <u>D130-780 / D412-698</u>	Created By: HS	Approved By: <u>AP</u>		
Product Name: AS 350 Spacepod/Hinge Door kits	Checked By: <u>MM</u>	General Manager Approval:		

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	<u>14/09/21</u>
Production Engineering Coord	Y	EC	<u>14/09/21</u>
Production Document Control	<u>N</u>	EC	
Customer Technical Support	<u>N</u>	EC	

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord	N		
QC Coordinator	N		
Marketing	N		
Customer Order Processing	N		

Reason for Change:
Prelimin Release for parts for testing

Documents Affected:
D3622 Rev. B
D3991 Rev. A
D3992 Rev. A

PARTS MUST COMPLY ☒ **PREVIOUS PARTS SATISFACTORY** ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	N			
9	Update Blue/Pink/DSI Folder and Electronic Files	N			
10	Update Controlled PDF Files	N			
11	Update Master Document List (MDL)	N			
12	Update Document Record (DR)	N			
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	<u>Y</u>	<u>KJ</u>		<u>09.09.21</u> <u>AP</u>
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	N			
18	Create / Update PPP's	N			
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	N			
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	N			
22					
23					

Description / Action:
 - Parts required for testing, to be sent to Calgary on or before 09.09.25
 - Quantity required; D3622-3 (2), D3991-1 (1), D3991-3 (1), D3992-1 (1), D3992-3 (1)
 - create estimates for D3622-3, D3991-1, D3991-3, D3992-1, D3992-3
 - AS PARTS WILL BE USED FOR TESTING NO FINISHING IS REQUIRED. NO DMT L CERTS

ECN Verified & Complete: MM

Date: 09/09/21